

Date: Thursday, 10/08/2006 10:01:26 AM  
 User: Linda Lacelle

## Process Sheet

*Split into SB 07/10/02*

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: N1 GEARBOX ACCESS PANEL KIT
Job Number	: 28125		
Estimate Number	: 12504		
P.O. Number	: <i>N/A</i>	Part Number	: D3255042
This Issue	: 10/08/2006 S.O. No. : <i>N/A</i>	Drawing Number	: D3255 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Ru	: <i>N/A</i>	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 31/08/2006 Qty: 4 Um: Each
Checked & / approved By	: <i>[Signature]</i>		
Comment	: Est Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32552	Panel
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)



Panel

Batch: *B28838*

*Pl 07.09.27*

2.0	D32553	Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)



Cap

Batch: *M21863*

*Pl 07.09.27*

3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3255

A/R SS ROD Batch: *M105138*

2-Grind Welds Flush

*Pl 07.09.27*

*(4)*

4.0	QC5/9	WELD INSPECTION
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Comment: WELD INSPECTION

*PD 07.09.28 (4)*

## Process Sheet

Cus omer: CU-DAR001 Dart Helicopters Services

Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 28125

Part Number: D3255042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

POWDER COATING

POWDER COATING



M104846



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

YS 07-10-02 (4)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



4X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-1 07/10/02

7.0

D32555

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Gasket

Batch: B28839

SB 07/10/03 (1)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255

A/R 736

DOW CORNING ADHESIVE Batch:

M15064

SB 07/10/03 1

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

En 07/10/03

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

07/10/03 (1)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

07/10/03

Job Completion



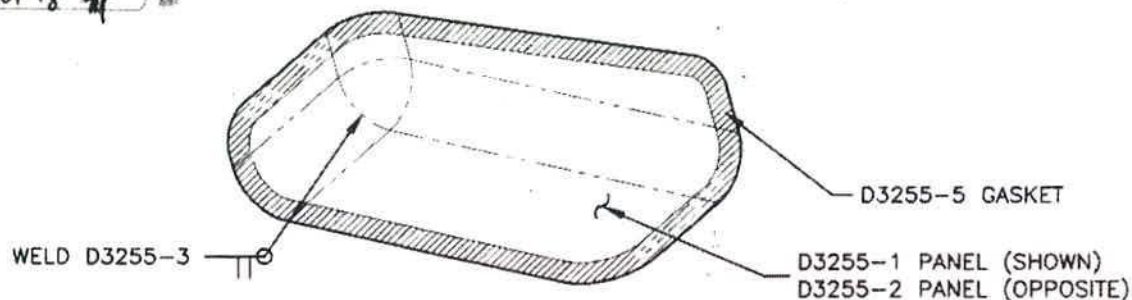
07/10/03

-042

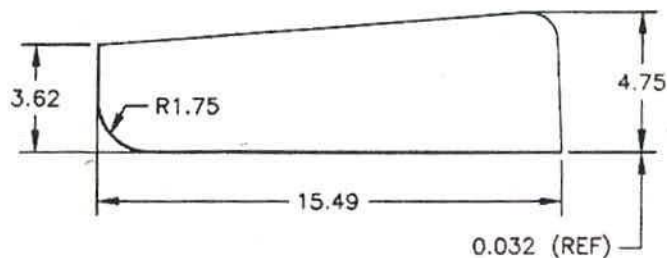
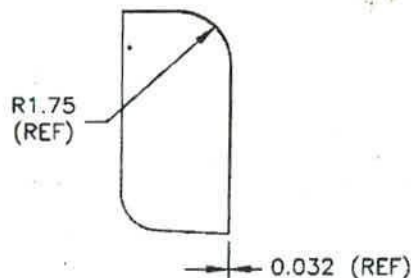
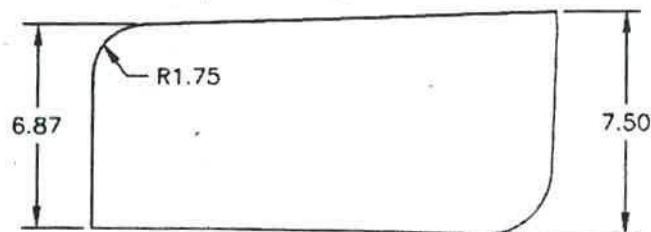


**DART**RELEASED  
05.01.18

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED H	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/02	8	Split w/o	JB	07/10/02	1		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries